

Work Order ID 160778

160778

Page 1

Thursday, May 04, 2017 6:39:15 AM

Item ID: D412-698-023 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Automatic Door Opener (fits LH or RH)
Start Date: 5/5/2017 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 5/15/2017 Req'd Qty: 6.00 *6* Customer:
Reference: SCHEDULED

Approvals: Process Plan: 21 Date: MAY 04 2017 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	F	MAY 04 2017							

100 Document Control 0.00
100 DOCUMENT CONTROL
DC Memo 0.00
Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D412-698-023 CHG003

110 Pick Kit 0.00
110 Packaging Memo 0.00
Packaging

120 QC4- 100% Inspect kits for completeness 0.00
120 QC Memo 0.18
Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

Work Order ID 160778

Thursday, May 04, 2017 6:39:15 AM

160778

Page 2

Item ID: D412-698-023

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/5/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/15/2017 Req'd Qty: 6.00

6

Customer:

Reference: SCHEDULED

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-698-023

Location: FG022

6 DAS
28
9-89

MAY 05 2017

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.60

17/5/18 JH

DAS
21
9-89

MAY 08 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : ☐							

Picklist Print

Thursday, May 04, 2017 6:39:25 AM

Page 1

Work Order ID: 160778

160778

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/5/2017

Required Date: 5/15/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-11		Manufactured	No			110	Each	21.0000	1	6			
----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3552-11

Door Prop

**

DAS
27
9-89

Location

Loc Qty

Loc Code

MAY 04 2017

FG

4

128491

2

151291

1

80345

1

ST363

17

158106

7

159139

10

D3594-043

Manufactured No

110

Each

8.0000

1

6

D3594-043

Floor Doubler Assembly, LH

**

MAY 04 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

Quarantine

1

147748

1

ST

1

148698

1

ST504

6

156974

2

158251

4

DAS
28
9-89

2
7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

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Page 2

Work Order ID: 160778

160778

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/5/2017

Required Date: 5/15/2017

Start Qty: 6.00

Required Qty: 6.00

D3594-044

Manufactured No

110

Each

11.0000

1 6

D3594-044

Floor Doubler Assembly, RH

**

MAY 04 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

Quarantine

1

147749

1

ST504

10

157017

2

158252

4

159708

4

DAS
28
9-89

2
4

D3594-5

Manufactured No

110

Each

12.0000

1 6

D3594-5

Doubler

**

MAY 04 2017

DAS
27
89

Location

Loc Qty

Loc Code

ST041

12

156326

1

156888

5

158834

6

DAS
28
9-89

1
5

D3622-1

Manufactured No

110

Each

55.0000

2 12

D3622-1

Ball Stud

**

MAY 04 2017

DAS
27
39

Location

Loc Qty

Loc Code

ST043

55

156483

15

158388

40

DAS
28
9-89

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Thursday, May 04, 2017 6:39:25 AM

Work Order ID: 160778

160778

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/5/2017

Required Date: 5/15/2017

Start Qty: 6.00

Required Qty: 6.00

MS20426AD4-4

Purchased

No

110

Each

2,688.000

2

12

MS20426AD4-4

Rivet

**

MAY 04 2017

DAS
27
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

1193

125445

1193

ST312

1495

m132536

1495

MS21073L5

Purchased

No

110

Each

30.0000

1

6

MS21073L5

Anchor Nut

**

MAY 04 2017

DAS
27
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST298

30

m135058

5

m137361

25

NAS1149D0516J

Purchased

No

110

Each

241.0000

2

12

NAS1149D0516J

Washer

**

MAY 04 2017

DAS
27
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST264

241

M134943

41

M137166

200

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

Work Order ID 160778

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Page 1

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/5/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/15/2017 Req'd Qty: 6.00

6

Customer:

Reference: SCHEDULED

Approvals: Process Plan:

Date: MAY 04 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

F

MAY 04 2017

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-698-023

CHG003

CB ⑥ MAY 04 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.18

Quality Control